

Blue Aug 2

Work Order ID 71936

Thursday, July 14, 2011 7:49:39 AM



Item ID: D206-642-341

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 7/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2650

F

100

0.00

DC

0.00

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

SRP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Set Up/
Run Hours

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Plan
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Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R L Aluminum Rod

4-Grind weld flush to cap on top surface only.

5-Cut aft end to lenth as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

3 DL 11/07/14

M112860
M115773 BE 11/07/14
BE 11/07/14

DL 11/07/14

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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

125

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



QC

IX

B11/07/19

L & BE4/07/19

W/O:		WORK ORDER CHANGES					
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Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.
cure time before cutting

Start Date: 11/07/10 Time: 9:00 am

Finish Date: 11/07/10 Time: 11:30

A/R: Sikaflex-291 M 11/25/10

Sikaflex expiry date: 12/01/15

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

DL 11/07/10

1 & BE 11/07/10

Dart Aerospace Ltd

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Thursday, July 14, 2011 7:49:39 AM

Accept

[illegible]

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Run Start

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

[illegible]

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Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

W/ 11 07 26 (1)

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

1 1/2 11/07/28

205

0.00



SprayPaint

Memo

0.00

Spray Painting

PRIME B 117319
PAINT DELFLEET BLUE B 118395
CLEAR DELFLEET B 118053

170 11-08-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-341 PAR #: _____ Fault Category: Inspection + Landing Gear (cross tubes) NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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<u>u/08/04</u>	<u>Pause to 205 should</u>	<u>Found After Pinner that the 4th hole from aft (saddle hole) was ground down so much</u>		<u>→</u>				
	<u>be on stop #18.</u>	<u>The Ridge was removed R.C. Lack of Attention when grinding the weld, missed at inspection.</u>		<u>See NCR 11-750</u>				

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

215

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

SCRAP

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Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R [] [] Sikaflex-291 [] [] [] []

Sikaflex expiry date: [] [] [] [] [] []

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R [] [] Sikaflex-291 [] [] [] []

Sikaflex expiry date: [] [] [] [] [] []

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: [] [] [] [] [] []

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:




SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
240  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
250  Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D206-642-341 Location: _____ PPP Rev: _____	0.00 0.00							

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 71936

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

ME
11-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 71936

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
 IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DS19440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS4-1032-130		Purchased	No			220	Each	2,518.000	54	54			
---------------	--	-----------	----	--	--	-----	------	-----------	----	----	--	--	--



Insert

Location	Loc Qty	Loc Code
ST281	8	
117331	8	
ST282	2510	
117717	510	
118237	1744	
118312	256	

AN960C10L	NAS1149C0332 R	Purchased	No			220	Each	0.0000	54	54			
-----------	-------------------	-----------	----	--	--	-----	------	--------	----	----	--	--	--



washer

AN960JD10L	NAS1149D0332J	Purchased	No			220	Each	0.0000	2	2			
------------	---------------	-----------	----	--	--	-----	------	--------	---	---	--	--	--



Washer

AN960JD416	NAS1149D0463J	Purchased	No				Each	0.0000		1			
------------	---------------	-----------	----	--	--	--	------	--------	--	---	--	--	--



Washer

Dart Aerospace Ltd

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Start Date: 7/14/2011

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Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

Each

519.0000

2



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

517

117086

59

117849

458



DL
11/07/05

CR3212-4-03

Purchased

No

Each

1,198.000

2



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1196

114859

1196



DL
11/07/05

D2620

Manufactured

No

Each

10.0000

1



Skidtube, 206 Skidtube

Location

Loc Qty

Loc Code

LG

10

68136

3

71616

7



DL
11/07/14

Thursday, July 14, 2011 7:49:35 AM

Shop Packet Print

Page 2

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Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured

No

220

Each

75.0000

1

1



Aft Cap

Location

Loc Qty

Loc Code

FP004

58

68280

58

FP006

5

62678

5

FP-4

1

70945

1

fp5

11

71038

11

D2647

Manufactured

No

Each

47.0000

1



Cap

Location

Loc Qty

Loc Code

LG002

47

55352

17

71171

30

D2649

Manufactured

No

Each

121.0000

19



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

109

68224

2

71355

107

LG001

12

65317

1

68507

11

BEU/07/14

BEU/07/21

Thursday, July 14, 2011 7:49:36 AM

Shop Packet Print

Page 3

Dart Aerospace Ltd

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Parent Item Name: Replacement Skidtube



Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

D2651-1

Manufactured No

220

Each

429.0000

14

14



Plug



Location

Loc Qty

Loc Code

fpa

109

69018

109

FP-A

320

57869

1

66445

10

67760

50

70691

100

70827

2

70839

4

70942

52

71037

101

D2651-3

Manufactured No

220

Each

438.0000

14

14



O-Ring



Location

Loc Qty

Loc Code

FP-A

438

61962

26

66956

412

D2654-5

Manufactured No

Each

0.0000

1



Web

D2680-041

Manufactured No

Each

23.0000

1



Nut Plate



Location

Loc Qty

Loc Code

ST020

23

55366

17

70088

6

Thursday, July 14, 2011 7:49:36 AM

Shop Packet Print

Page 4

72140

Dr.
11/07/00

Dr.
11/07/05

W/O:		WORK ORDER CHANGES					
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Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-11

Manufactured No

220 Each

22.0000

1 1



Wearshoe

Location

Loc Qty

Loc Code

FP019

22

68362

1

70879

8

71284

13

D3535-23

Manufactured No

220 Each

38.0000

1 1



Wearshoe

Location

Loc Qty

Loc Code

FP021

38

68342

10

70818

16

71581

12

D3535-35

Manufactured No

220 Each

31.0000

1 1



Wearshoe

Location

Loc Qty

Loc Code

FP018

14

65926

1

67598

1

70815

12

ST

17

69756

17

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 71936

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube



Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-11

Manufactured No

220

Each

19.0000

1

1



Gasket



Location

Loc Qty

Loc Code

FP011

19

46649

1

46715

4

65574

1

71283

13

D3536-23

Manufactured No

220

Each

39.0000

1

1



Gasket



Location

Loc Qty

Loc Code

FP011

39

43406

1

66560

1

69902

25

71579

12

D3536-35

Manufactured No

220

Each

31.0000

1

1



Gasket



Location

Loc Qty

Loc Code

FP012

31

69755

17

71587

14

D3537-1

Manufactured No

220

Each

34.0000

6

6



Wearpad



Location

Loc Qty

Loc Code

FP017

34

69817

5

70686

29

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Page 6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 14, 2011 7:49:36 AM

Page 7

Work Order ID: 71936

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube



Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-3

 Manufactured No
 Wearpad

220 Each 6.0000 1 1



Location Loc Qty Loc Code

FP017	6	
35697	1	
70817	5	

MS27039-4-06

 Purchased No
 Screw

220 Each 50.0000 1 1



Location Loc Qty Loc Code

FP-A	16	
115460	16	
ST292	34	
115460	34	

MS27039C1-08

 Purchased No
 SCREW

Each 1,292.000 56



Location Loc Qty Loc Code

FP-A	1	
116022	1	
ST293	1291	
116373	3	
117291	288	
118077	500	
118159	500	

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Page 7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

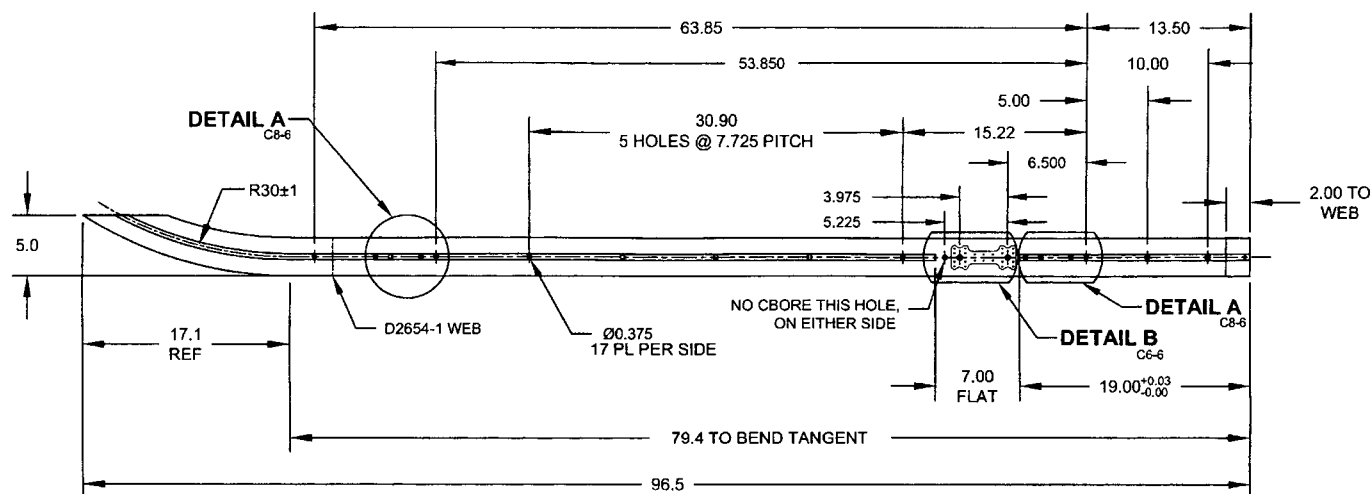
QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

NOTES:

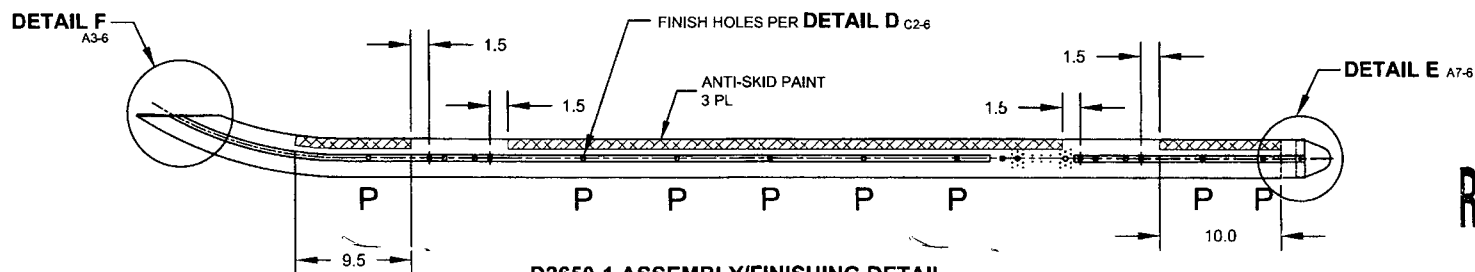
- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
08-07-23/17

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small> COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. </small>	



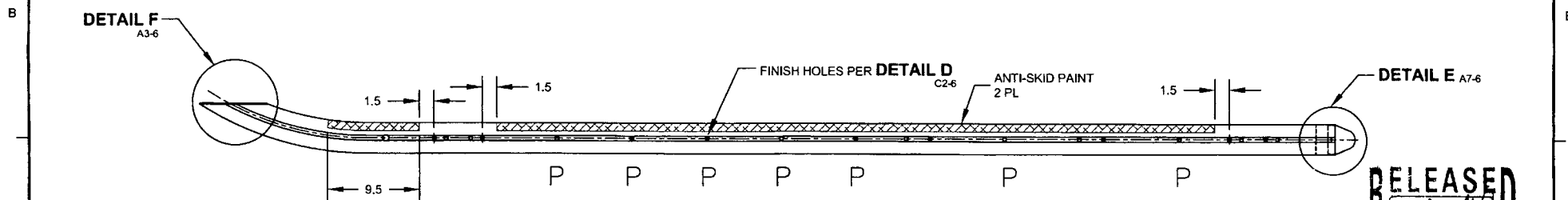
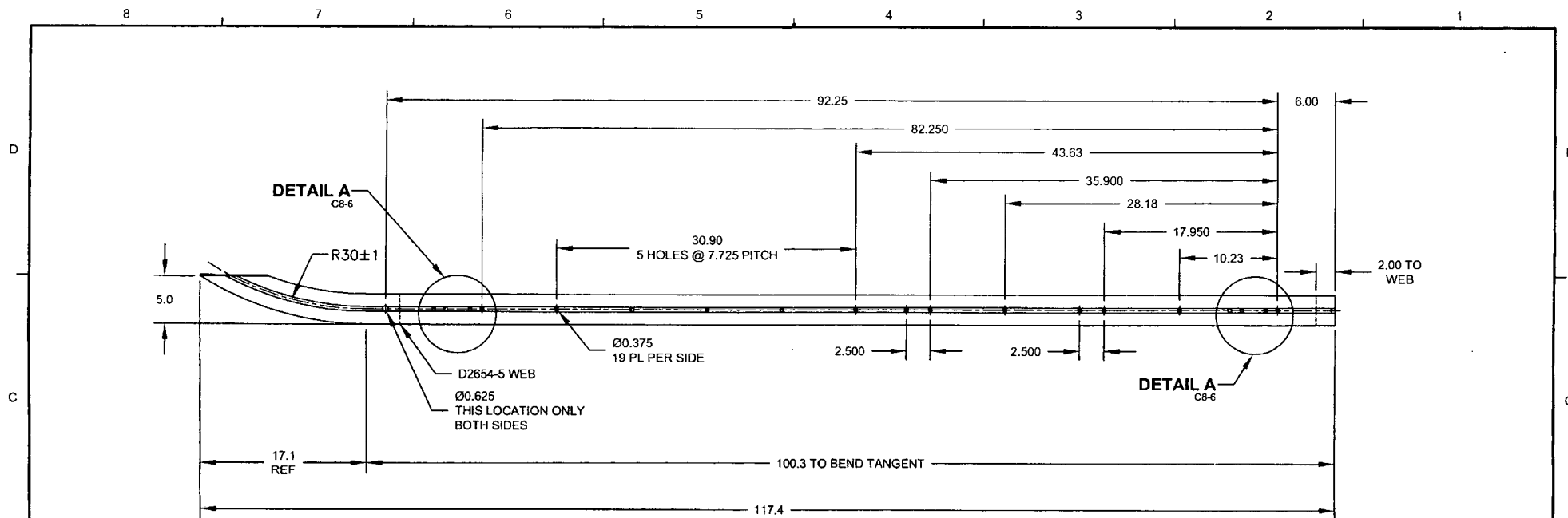
D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

RELEASED
680922/117

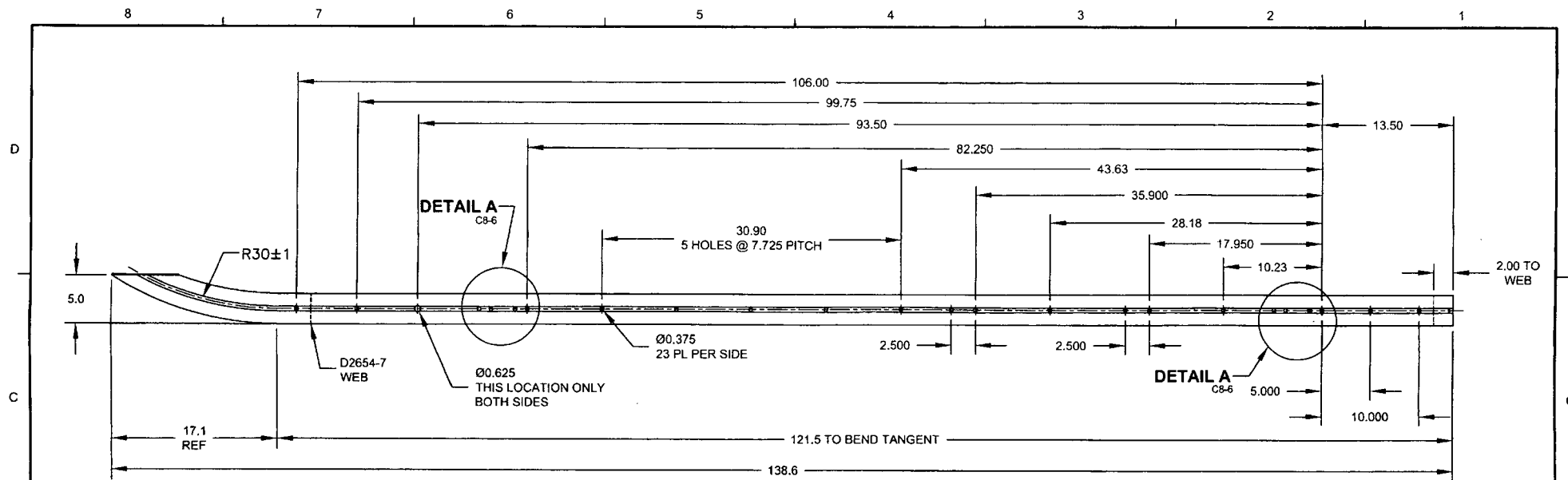
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MFG. APPR.		D2650	SHEET 2 OF 6
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D2650-5 ASSEMBLY/FINISHING DETAIL

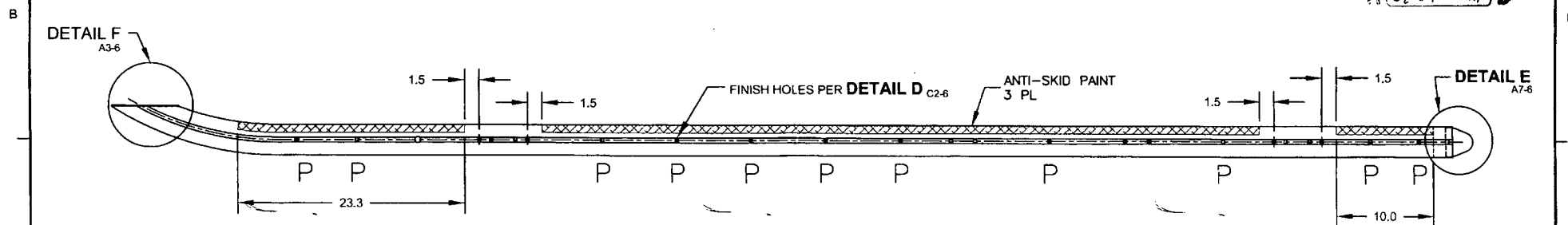
71936

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CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	J	D2650	SHEET 4 OF 6
APPROVED	J	TITLE	SCALE
DE APPR.	J	206/407 SKIDTUBE ASSEMBLIES	NTS
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D2650-7 BENDING/DRILL DETAIL

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08-07-22



D2650-7 ASSEMBLY/FINISHING DETAIL

71936

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MFG. APPR.		D2650	SHEET 5 OF 6
APPROVED		TITLE	SCALE
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